0.00

Memo

QC

Quality Control

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-	CON	IFORM	MANCE / UPI	DATE	QA Closed:	Date:	
Work Order	÷:				DISPOSITION				AGAINST DE	EPARTMENT	PROCESS	5
Part No					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	<b>→</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Sten	Otv		ption of work order update or Non-conformance		nitial ief Eng	Act Descr	ion iption	Sign & Date	Verification	QC Inspector
occ/Data quip/Tooling Operator Material etup Other Process upplier Training	ta poling por											
					F	AUL	T CATE	GORY				
Landin	Bending Centre No Cracks		ntric to (	o/s	General Bend BOM/Route Broken/Damaged		•	on Incomplete		Ovalized Over/Under Part Incorred	t ·	Pressure/Forced Temperature/Cure Weld
-	Crushed/ Cuffs Heat Trea	at n Strip in	Tube		Burrs Contamination Countersink Cut Too Short		Mainte Mislabe Misreac	eled	Jnclear	Part Lost/Mi Part Moved Positioned W Power Loss/	/rong	Wrong Stock Pulled Other
}	Ripples in Torque W	Vaves in E equence			Drill Holes Drawing Finish Folio		Out of S	Calibration Sequence				
	Wave/Tw	ist in lut	e.	ı	ורטווס	1 1	Outside	Dimensions				

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Work Orde	er ID 1	00941		*11	$\cap \cap \cap$	<b>4</b> 1*						Page 2
May-01-13 7:09	2:43 AM				, , , , , ,	41						
Revision ID:	D4012-1 Cushion			Accept	*	N900	<b>040</b>	100	<b>)*</b> s	Setup Star	1 71	S1* S2*
Start Date: Required Date: Reference:	4/30/13 4/30/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item I Customer:	D:	:				 
Approvals:	Process P	lan:	Date:	Tooling:		Da	ate:		. <b>F</b>	tun Stai	1/1	R1*
	QC:		Date:	SPC (Y/N):	-	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center II	)	Operation Description	,	Set Up/ Run Hou	ırs	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*123 *123* Small Fab		Мето		0.00					20	\$		13-
Small Fab			D FORM CUSHION AS P F GUN, LET IT COOL DO									
126		QC5- Inspect part comple	eteness to step on W/O	0.00	4)							
*126* QC Quality Control		Мето		0.00 13	. 6./ <b>1</b>				26			

130

Identify as per dwg & Stock Location: 51458

\*130\* Packaging

Quality Control

Memo

Packaging

0.00

Laox M.10-13-06-11

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-C	10:	NFORM	MANCE / UP	DATE			
											QA Closed	Date	:
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	-				<del>.</del>	Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
raiti	•0			· · · · · · · · ·		Use-as-is			noforming	Finishing	4	re/Packaging	Other
NCR N	No	•			<u> </u>	Work Order Update	·		Large Fab	Composite	1.00,010	Supplier	
Root			***		Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							l						
Operator													
Material													
Setup													
Other													
Process			i										·
Supplier		İ											
Training					:		1						
Unapproved	П												
	•					F/	٩UL	T CATE	GORY				
Landi	ng G	ear				General		_			-		- <b>-</b>
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route	Ĺ	Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	П	Heat Trea	t			Countersink	Γ	Mislabe	led		Positioned \	Wrong	<u> </u>
		Inspection	n Strip in	Tube		Cut Too Short	Г	Misread	I		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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Work Order ID 100941 May-01-13 7:09:43 AM				*100		·						
Item ID: Revision ID:	D4012-1			Accept	*N900	<b>040</b>	100	)* s	etup Sta	IV	IS1*	
Item Name:	Cushion		•		•				Sto	<sub>в</sub> *N	IS2*	
Start Date: Required Date:	4/30/13 4/30/13	<b>Start Qty:</b> 20.00 <b>Req'd Qty:</b> 20.00	*20* *20*		Cust Item I Customer:	D:						
Reference:										-4.		
Approvals:	Process	s Plan:	Date:	Tooling:	Da	ate:		ŀ	tun Sta	1/	IR1*	
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ate:			Sto	'p *N	IR2*	
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*140* QC Quality Control		Мето		0.00				MG	s <u>13-</u>	06-17 VM		
										(2)	F 5-6-11	

NCR: Y	es / N	o			WORK ORDER NON-	COI	VFORI	MANCE / UPE	DATE			
							ī			QA Closed:	Date:	
Work Orde	r:				DISPOSITION	,				EPARTMENT	-	
Part N	o				Rework Scrap		l	Skid-tube Machining	Crosstube Small Fab	<b>-</b>	Water Jet d. Eng. Coor	Engineering Quality
NCR N	lo			·	Use-as-is Work Order Update	_		noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	iption of work order update	П	nitial	Act	ion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data quip/Tooling												
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etup					•							
)ther	_											Í
rocess	_											
upplier	$\dashv$											
raining Inapproved	-	1										
арріочеа		I	,	1		AUL	T CATE	GORY	<del>- · · · - </del>	<u> </u>		
Landin	ng Gear				General							
ſ	Bendi	ng			Bend		Grain			Ovalized		Pressure/Forced
	Centr	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
[	Crack	5			Broken/Damaged		Inspecti	ion Incomplete		Part Incorre	ct	Weld
	Crush	ed/Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Cuffs			L	Contamination		Mainte	enance		Part Moved			
	Heat	reat			Countersink		Mislabe	eled		Positioned V	Vrong	_
	inspe	1 Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other	
[	Ripple	s in Bend			Drill Holes		Offset					
Ţ	Torqu	e Waves in	Extrusio	n $lacksquare$	Drawing		Out of 0	Calibration				
ľ	Turnii	ng Sequence	9		Finish		Out of 9	Sequence				
Wave/Twist in Tube					Folio		Outside	Dimensions				

DQA:

Date:

May-01-13 7:09:42 AM

Work Order ID:

100941

Parent Item:

D4012-1

Parent Item Name:

Cushion

**Start Date:** 4/30/13

Required Date: 4/30/13

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP RevA: New issue 09.10.28 DD verified by:JLM

IPP RevB: revA as per dwg

09.11.18 DD verified by:JLM

7.11.16 DD VOITION

IPP Rev:C 11.01.10 as per dwg Rev.B DD verified

by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	48.4000	0.37	7.789474			
UHMW U-Channel													

 Location
 Loc Oty
 Loc Code

 ST202
 6.4
 1, 2

 91102
 6.4
 2

 ST209a
 42
 42

 97824
 42
 42

MSP 13/06/05

NCR:	Yes	/	No
TTCIT.	, ,	,	140

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: YE	52 \ NO			WORK ORDER NON-	·COi	IFORI	VIANCE / OPI	DATE	QA Closed:	Date:	
Work Ordei	r:			DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part No	<del></del>			 Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab	-	Water Jet	Engineering Quality
NCR N	0	•		 Use-as-is Work Order Update			noforming	Finishing Composite	Kec/Stoi	e/Packaging Supplier	Other
Root				ption of work order update	•	nitial		tion	Sign &		
Cause	Date	Step	Qty	 or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
quip/Tooling Operator Material etup Other Process upplier Training								,			
Inapproved	<u> </u>	<u> </u>	<u>.                                    </u>		L FAUL	T CATE	GORY				
Landin	g Gear			 General							-
-	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube Extrusion	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/U nance iled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
T T	Wayo/Tu			Teolio		Outside	Dimensions				

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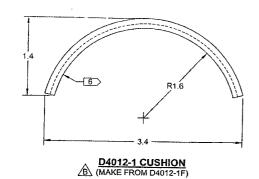
DART AEROSPACE LTD	Work Order:	100941
Description: Cushion	Part Number:	D4012-1
Inspection Dwg: D4012 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

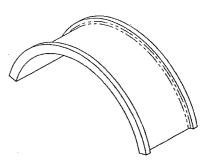
TINGT ARTICLE MOPLETION CHECKLIST												
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments						
1.25	+/-0.030	1,247			MUP-04	vern						
1.050	+/-0.010	1.060			11.1	111						
0.10	+/-0.030	0.107	<b>V</b>		111	117						
4.41	+/-0.030	1,060 0,107 4,415			111	, , ,						
ÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜÜ	UNI E VERBARANI	MMM (10	MIM	MAN								
0.17	+/-0.030	0,181	/		MIP-04	vern						
0,076	+ 0,05	0,087	V		111	111						
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Measured by:	Audited by	" FX	Preliminary Approval:	
Date: /3/0	6/05 Date	13/06/05	Date:	

4	Rev	Date	Change	Revised	l by	Approved //
Í	Α	11.01.17	New Issue	KJ	10	1
	В	12.08.02	Dwg Rev updated	KJ S	AT.	CM/
•		_			<i>[]</i>	



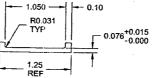
SHO Th Part Mark  $12^{9}$ PO MODAY STANCE A V/111 130503



0.17

В





DELEASED 2010 -12- 23

ı			 . :	
	NOTES:  1) MATERIAL: MAKE FROM D4287-3 (B)  2) FINISH: NONE  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  4) UNITS: INCHES UNLESS OTHERWISE NOTED  5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.7) WEIGHT: 0.02 lbs	3.1		

В	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH MB 10.12.07 RADIUS. REF: PARI-0-29						
Α	NEW ISSUE				09.10.19		
REV.	REV.		DESCRIPTION	BY	DATE		
DESIGN			DART AEROSPACE LTD				
DRAW	V		HAWKESBURY, ONTARIO, CANADA				
CHECK	ED_	AND	DRAWING NO.		REV. B		
MFG. APPR.  APPROVED		Con	D4012		SHEET 1 OF 1		
		W	TITLE		SCALE		
DE APF	PR.	-#	CUSHION		итѕ		
DATE	10.1	2.07	COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IN PROVISE ON CONTROL OF A SPACED ON THE SPACES CONTROL THAT IT IS  107 TO BLUSS I FOR ANY PURPOSE ON CONTROL ON CONSIDERATION TO ANY OTHER TROOPS ON CONTROL ON CONT				

4